

**Work Order ID 60846**

Monday, July 26, 2010 10:40:54 AM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 7/26/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*

Date:

*10-7-26*

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2230

Rev *P* *G**CE**10.07.29*

100

0.00



BAND SAW

Bandsaw

Memo

0.00

*cmf 10/07/27**100**0*

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"  
Batch: *45800*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

*cmf 8/10/29**100**0*

HAAS CNC vertical machine #1

1-Machine per folio FA927  
FOLIO REV: *AA*  
DWG REV: *G*  
Check for crack while loading into the machine.  
2- deburr

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*OK 10/07/29*100 0 \_\_\_\_\_

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*K.A 10/08/01*100 0 \_\_\_\_\_

150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*M 10/08/01*100 0 \_\_\_\_\_

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

100 BL 10-8-3

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:00  
OVEN TEMPERATURE: 320°  
FINISH TIME: 9:30

100 BL 10-8-5

180

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

M 10 08 05 (100)

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Page 4

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Item Name: Lug

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Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>ST 476</u>	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
200	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

x100

BB

10/08/18

10/08/19

MF

10-8-18

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, July 26, 2010 10:40:59 AM

Page 1

Work Order ID: 60846



Parent Item: D2230-3



Parent Item Name: Lug


Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC  
25 JLM VERIFIED BY:EC  
☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423  Lug Extrusion		Manufactured	No			100	f	393.6932	0.0683	7.189474			



Location

Loc Qty

Loc Code

MAT06

393.6931695

43722

180

→ 45800

213.693169

7.1894 *amk 10/07/207*

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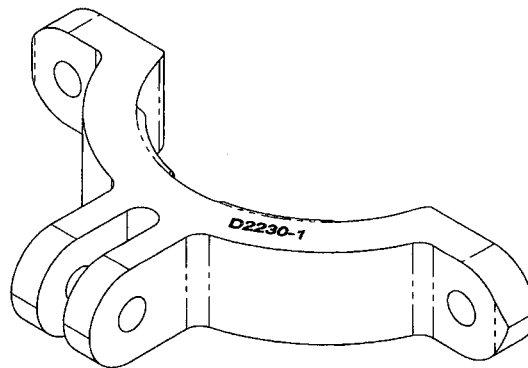
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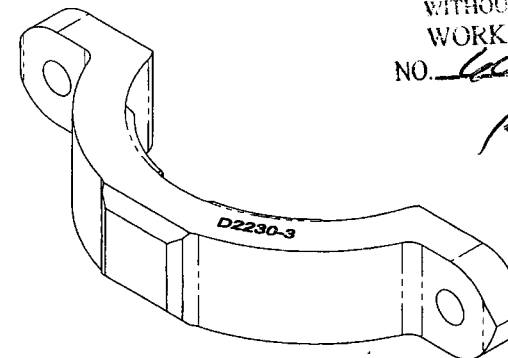
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**NOTE:** Date & initial all entries

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 60844  
plw 724



**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

**RELEASED**  
 09/01/16



**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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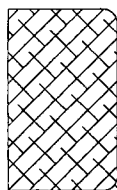
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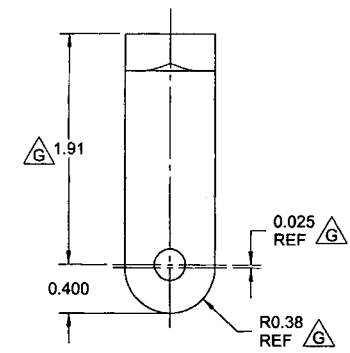
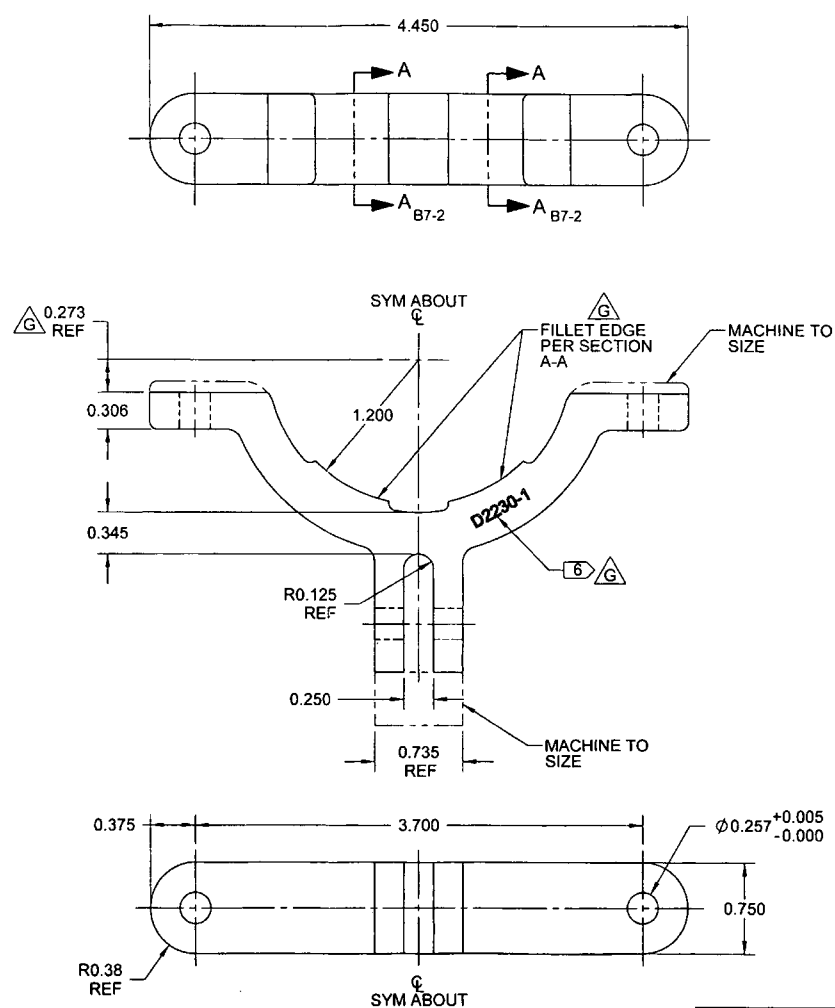
**NOTE:** Date & initial all entries

W60844

**SECTION A-A** D4-2  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL



**D2230-1 MOUNTING LUG**

**RELEASED**  
09/06/25/17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D2230</b>	REV. G
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		<b>MOUNTING LUG</b>	SCALE
DE APPR.			NTS
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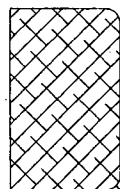
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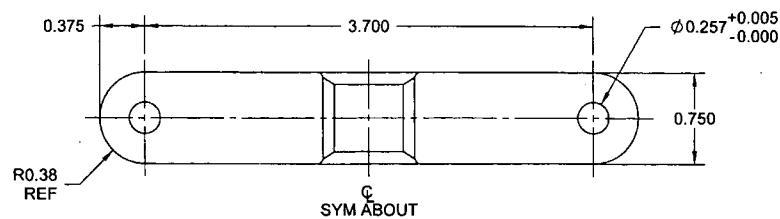
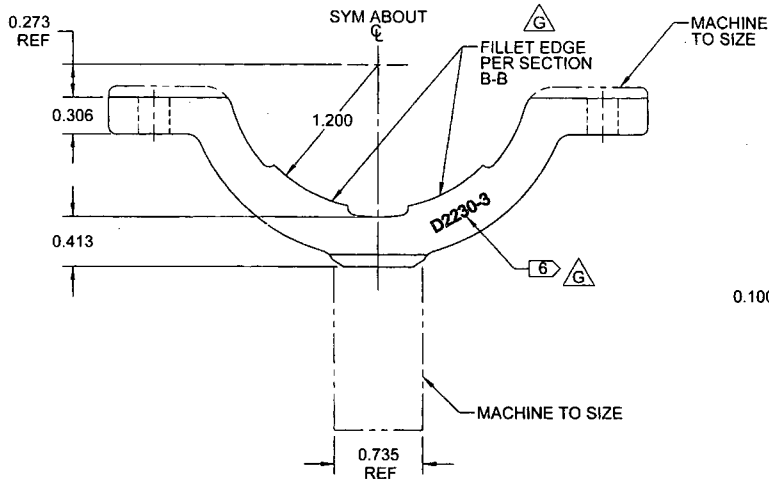
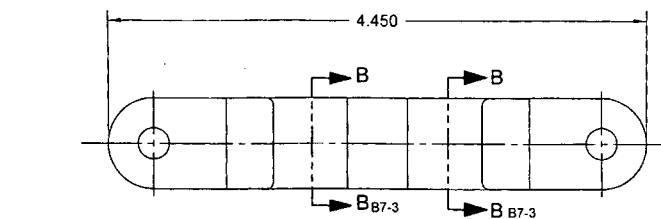
**NOTE:** Date & initial all entries



**SECTION B-B**  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL



**D2230-3 MOUNTING LUG**

*Handwritten signature: a/c 60846*

**RELEASED**  
09/06/15

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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